

3041500

Work Order ID 80245

80245

Page 1

February-15-12 3:30:57 PM

Item ID: D3443-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clevis

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: AADWG REV: C

2-DEBURR AS REQUIRED

SL 12-05-28

(10)

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

SL 12-05-28

10

160

QC8- Inspect parts - second check

0.00

160

QC

Memo

0.00

Quality Control

SL 12/05/28

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 80245

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February-15-12 3:30:57 PM

Item ID: D3443-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clevis
 Start Date: 15/02/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>U/A</u>	0.00							
170									
Packaging	Memo	0.00				10			12-05-29 JBL
Packaging	*****STOCK IN LARGE FAB*****								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/5/30 

mf
12-05-29

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Picklist Print

February-15-12 3:31:01 PM

Page 1

Work Order ID: 80245

80245

Parent Item: D3443-3

D3443-3

Parent Item Name: Clevis

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A05.11.14New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.500		Purchased	No			100	f	24.3000	0.35	2.5			

M304R1 500

304 round bar 1.500

**

12-05-28

Location	Loc Qty	Loc Code
MAT029	24.3	
114676	0.3	
119231	12	
120127	12	

x 3.0

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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 80245
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.70	✓		Vern	SL-10
0.95	+/-0.030	.930	✓			
Ø0.500	+0.000/-0.005	.498	✓		mic	SL-4
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	.450	✓			
Ø0.375	+0.006/-0.001	.377	✓		Vern	SL-10
0.551	+/-0.010	.555	✓			
0.625	+/-0.010	.624	✓		H-G	
1.43	+/-0.030	1.425	✓		H-G	
0.820	+/-0.010	.818	✓			
0.05 x 45°	+/-0.5°	.05x45°	✓		Vern	
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	.996	✓			
1.125	+/-0.010	1.122	✓			
0.438	+0.005/-0.000	.442	✓			
R0.219	+/-0.010	.221	✓			

Measured by: SL	Audited by: [Signature]	Preliminary Approval:
Date: 12-10-27	Date: 12/05/28	Date:

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev C	KJ	
C	11.10.13	Dimensions revised	KJ [Signature]	[Signature]

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RELEASE
09/08/25 MP

W/O:		WORK ORDER CHANGES					
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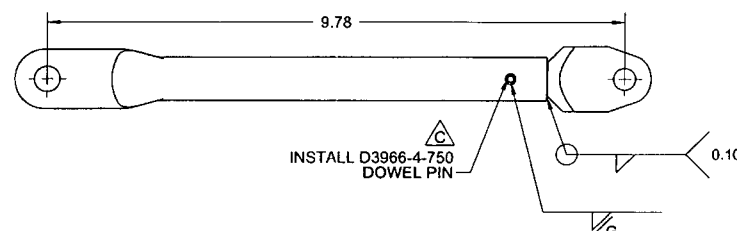
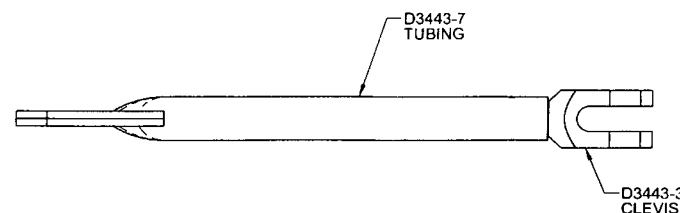
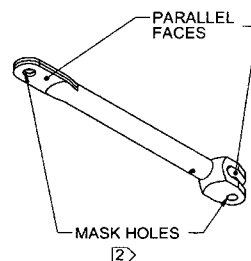
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80245

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

RELEASED
09/06/25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CA	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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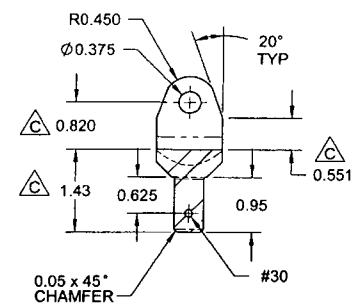
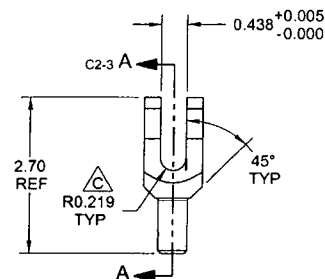
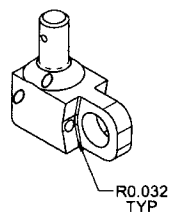
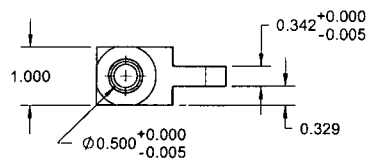
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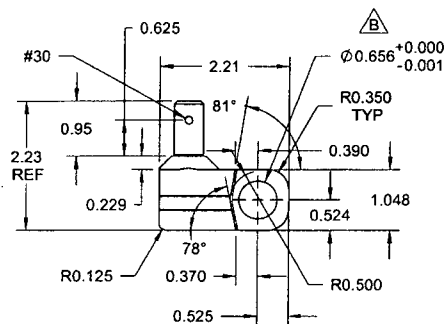
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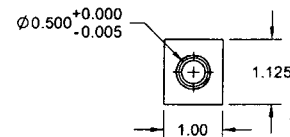
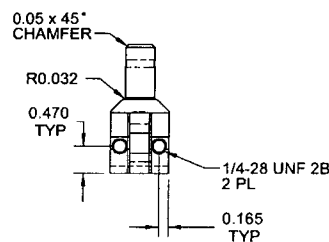
80245



SECTION A-A C4-3



D3443-1 LUG





D3443-3 CLEVIS

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

RELEASED
07/08/25/14

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-268

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

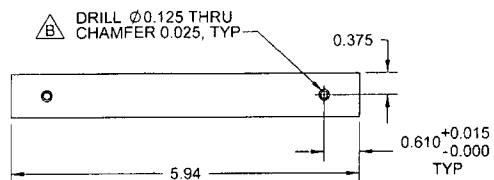
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

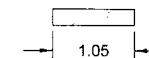
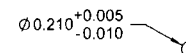
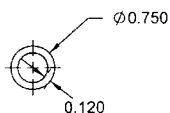
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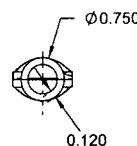
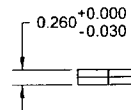
80245



D3443-5 TUBING

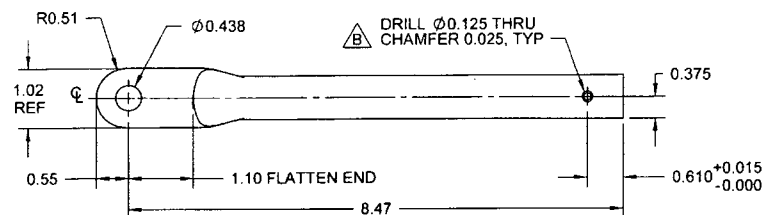


D3443-9 PIN



D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
01/08/25 11/25

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